

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2016-140 Date Opened: 19 Oct 16 Title: FabricationAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Handle Product Model: High Quantity: 2**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

DB
N/A
DB
DB
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
84261	2	Handle Assembly	DB
36277	1	Handle Bar	DB

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

2
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: Andrew BartfaiSign: SCA: AD07Date: 19-Oct-16

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 19-Oct-16

Work Order closed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 19-Oct-16

Approved Manufacturing Facility 73-04

Form 20.D/03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0203
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2016-140
6. Item 1.	7. Description Handle Assembly	8. Part Number 84261-01	9. Qty. 2	10. Serial/Batch No. N/A	11. Status/Work New
12. Remarks for Bell 206L/407 High Mount Basket					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 19 Oct 2016		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

ALPINE HELICOPTERS

**Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

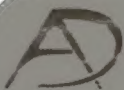
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: HAND BRACKET ASSY No. of pieces: 4Manufacturer: AERO DESIGN LTD.Part No.: 84263-02 Serial No.: NSNTTSN: N/A TSO: N/A Rem.: N/AWork Order No.: 2016-54Remaining Tasks to be Performed: NONESignature: JH CRL **AD**Date: 19 OCT 2016 Lic. No. / SCA **73-04**

Form# 20.E.02

Rev. 1 24 April 2014

Serviceable**Aero Design Ltd.**

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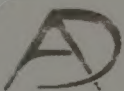
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BUSHING No. of pieces: 8Manufacturer: AERO DESIGN LTD.Part No.: 84272-01 Serial No.: NSNTTSN: N/A TSO: N/A Rem.: N/AWork Order No.: 2016-134Remaining Tasks to be Performed: NONESignature: JH CRL **AD**Date: 19 OCT 2016 Lic. No. / SCA **73-04**

Form# 20.E.02

Rev. 1 24 April 2014

Serviceable**Aero Design Ltd.**

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BUSHING No. of pieces: 4Manufacturer: AERO DESIGN LTD.Part No.: 36275-01 Serial No.: NSNTTSN: N/A TSO: N/A Rem.: N/AWork Order No.: 2016-132Remaining Tasks to be Performed: NONESignature: JH CRL **AD**Date: 19 OCT 2016 Lic. No. / SCA **73-04**

Form# 20.E.02

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Remarks



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Remarks



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AMF 73-04

Serviceable

Remarks

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order:

2016-140

Date Open:

Oct 19th/2016

Complete

(initial or SCA #)

1. Weld Lever Assembly – handle lever jig required
 - a. Set MS20615-4M3 monel rivet into socket in jig
 - b. Set 36274-01 bushing into socket in jig
 - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
 - d. TIG weld around bushing using ER308L rod.
 - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
 - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
 - g. Record material POs on attached material list.

Previously C/W

AD
73-04
07

AD
73-04
07

2. Clean up
 - a. Clean lever assembly by media blasting with glass bead.
 - b. Drill out lever bushing to O (0.316) on lathe:
 - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
 - ii. Run at 300 RPM.
 - iii. Apply a drop of Rapid-Tap to drill.
 - c. De-burr.

AD
73-04
07

AD
73-04
07

3. Fabricate Handle Assembly
 - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
 - b. Measure across TOP side of levers.
 - c. Cut handle tubing to length measured.
 - i. Handles under 40" long: 1.0" x 0.035 round tube
 - ii. Handles over 40" long: 1.0" x 0.065 round tube
 - d. De-burr tube.
 - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
 - f. Record material PO on attached material list.

AD
73-04
05

AD
73-04
05

4. Weld Handle Assembly
 - a. Fuse tube to lever on both ends. Ensure levers are parallel.

AD
73-04
07

AD
73-04
07

5. Clean up
 - a. Clean welded area with scotch-brite.

AD
73-04
02

AD
73-04
02

6. Final Inspection –

To be completed by a different person than the previous steps.

 - a. Welds for complete and handle for fit.
 - b. Tag complete and inspected parts in preparation for installation.

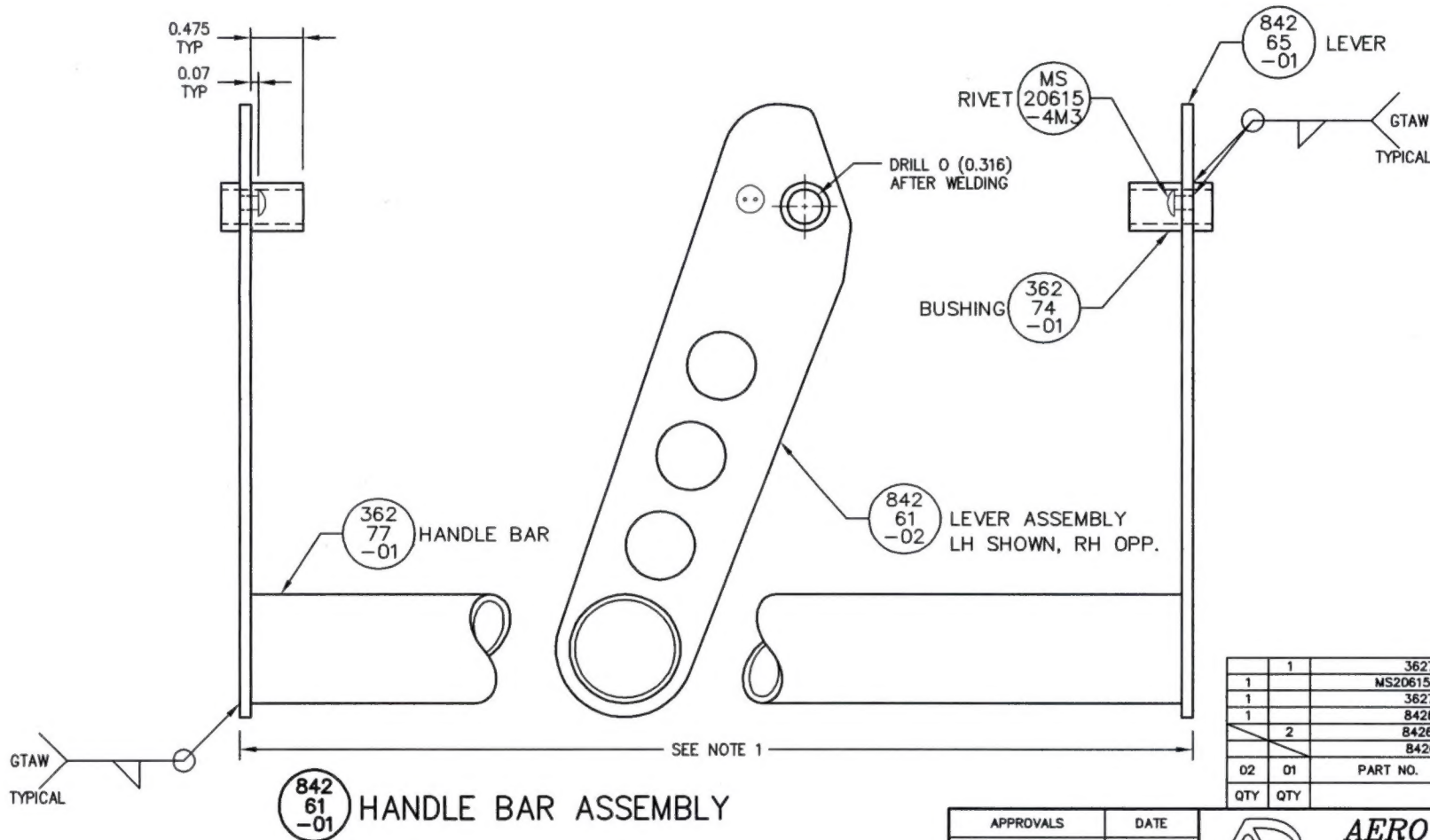


WO# 2016-140

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1	1	MS20615-4M3	RIVET (MONEL)
1	1	36274-01	BUSHING
1	1	84265-01	LEVER
2	1	84261-02	LEVER ASSEMBLY (RH/LH)
2	1	84261-01	HANDLE BAR ASSY

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



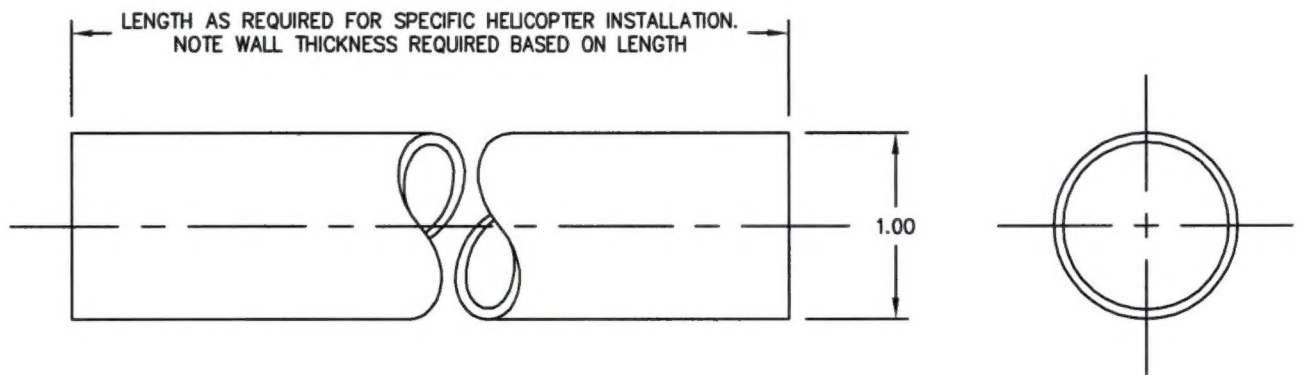
AERO DESIGN LTD.

9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.5376 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY**

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36210	STF	MAY 17/02
1	UPDATE TITLE BLOCK, ADD ALTERNATE MATERIALS	BJC	MAR 13/14




01 HANDLE BAR

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.

	01	(ALTERNATE MATERIAL)	316 STAINLESS STEEL	ASTM A213	1.0" X 0.065" TUBE
	01	HANDLE BAR (OVER 40")	304 STAINLESS STEEL	ASTM A213	1.0" X 0.065" TUBE
	01	(ALTERNATE MATERIAL)	316 STAINLESS STEEL	ASTM A213	1.0" X 0.035" TUBE
36277-01	01	HANDLE BAR (UP TO 40")	304 STAINLESS STEEL	ASTM A213	1.0" X 0.035" TUBE
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

QTY	LIST OF MATERIALS
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	DRAWN: STEVEN FAHEY	MAY 17/02				
	CHECKED: E. BURGOIN	MAY 01/03	HELICOPTER CARGO BASKET HANDLE BAR			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:					
	DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1					
NOTICE	SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.	
	SHEET 1 OF 1		A4	36277	1	